

What is claimed is:

1. A screen printing method for printing paste on a work via pattern holes formed on the mask plate, comprising:

5 a mask attachment step in which said work is brought into contact with the lower surface of said mask plate;

a squeegeeing step in which a squeegee is moved on the mask plate in the mask attachment state thereby to filling paste into said pattern holes; and

10 a plate separating step in which the work is separated from the mask plate stepwise by a plate separating operation of repeating plural times an acceleration and deceleration pattern in which a moving speed at which said work is moved in the direction where the work separates from the mask plate is accelerated up to an upper limit speed and thereafter is
15 decelerated up to a lower limit speed,

wherein an initial upper limit speed representing said upper limit speed in start of said plate separating operation is set higher than succeeding upper limit speeds representing
20 the upper limit speeds from the middle of the plate separating operation on.

2. The screenprinting method according to Claim 1, wherein in said plate separating operation, a plurality of said
25 acceleration and deceleration patterns are set so that said succeeding upper limit speeds are decelerated gradually.

3. The screen printing method according to Claim 1, wherein
in start of said plate separating operation, a plurality of
said acceleration and deceleration patterns are set so that
5 acceleration and deceleration is repeated at the nearly equal
initial upper limit speed.

4. The screen printing method according to Claim 1, wherein
in the plate separating operation, said work is separated from
10 the mask plate by causing the work to descend.

5. A screen printing method for printing paste on a work
via pattern holes formed on the mask plate, comprising:
a mask attachment step in which said work is brought
15 into contact with the lower surface of said mask plate;

a squeegeeing step in which a squeegee is moved on
the mask plate in the mask attachment state thereby to filling
paste into said pattern holes; and

a plate separating step in which a plate separating
20 operation of moving said work plate in the direction where
the work separates from the mask plate is performed,

wherein in start of said plate separating operation,
the moving speed is accelerated up to an upper limit speed
and thereafter is decelerated up to a lower limit speed.

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6. The screen printing method according to Claim 5, wherein
in a process where in start of said plate separating operation,
the moving speed is accelerated up to the upper limit speed
and thereafter is decelerated up to the lower limit speed,
5 acceleration and deceleration are not repeated but deceleration
is performed continuously.

7. The screen printing method according to Claim 5, wherein
in the plate separating operation, said work is separated from
10 the mask plate by causing the work to descend.